

Work Order ID 130766

130766

Page 1

Wednesday, March 25, 2015 11:27:29 AM

Item ID: D4983-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cargo Hook Assembly
 Start Date: 3/25/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 3/25/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1503-25 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4983	<u>FC 15/03/25</u>

100 0.00

100

Purchasing

Purchasing

Memo

ISSUE PO : 27895
 TO: RED BARN (DART EUGENE)
 C OF C IS REQUIRED

0.00

CZ 15/03/25 ①

110 Receive & Inspect for Damage & Mat'l Certs 0.00

110

Packaging

Packaging

Memo

0.00

IX SP15-05-20

120 QC5- Inspect part completeness to step on W/O 0.00

120

QC

Quality Control

Memo

INSTALL D5066-115 PLACARDS AS PER DWG

0.00

Ref Batch. 01-16263-A-08

DAS
38
9-89

MAY 27 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Start Date: 3/25/2015 Start Qty: 1.00 ***1*** Cust Item ID:
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location: *st 4/6*

0.00

130

Packaging

Memo

0.00

Packaging

~~D49~~

27

~~999~~

MAY 27 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MAY 28 2015

*MCJ**MCJ*

MAY 28 2015

DQA: _____ Date: _____



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Unapproved									

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		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

Wednesday, March 25, 2015 11:27:34 AM

Page 1

Work Order ID: 130766

130766

Parent Item: D4983-041

D4983-041

Parent Item Name: Cargo Hook Assembly

Start Date: 3/25/2015

Required Date: 3/25/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 14-03-022 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4983-041P		Purchased	No				Each	0.0000		1			
D4983-041P									**				
Cargo Hook Assembly													
D5066-1		Purchased	No				Each	0.0000		1			
D5066-1									**				
Cargo Hook Placard													
D5066-5		Manufactured	No				Each	28.0000		1			
D5066-5									**				
Placard (Load Limit)													

Location

Loc Qty

Loc Code

ST145

18

129338

18

ST459

10

128727

10

Handwritten: 1/8/2015-05-20

Handwritten: N/A

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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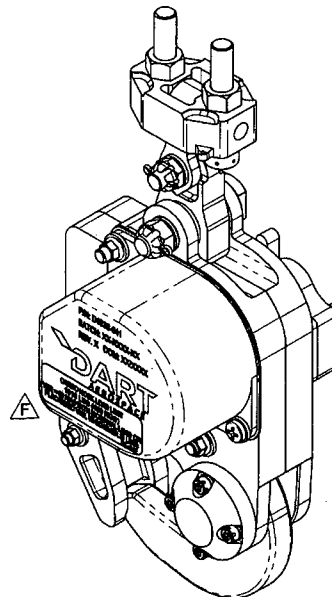
ITEM	QTY -041	P/N	DESCRIPTION
	X	D4983-041	CARGO HOOK ASSY
1	1	D4984-041	HOOK SIDE PLATE ASSY
2	1	D4985-041	HOOK SIDE PLATE ASSY
3	1	D4986-1	CARGO HOOK LOCK
4	2	D4987-1	DUST SHIELD
5	1	D4988-1	KEEPERLESS ADAPTOR
6	1	D4989-1	LATCH SHAFT
7	1	D4990-041	ACTUATOR ASSEMBLY
8	1	D4991-1	LATCH ROLLER PIN
9	1	D4992-1	LATCH ROLLER
10	1	D4993-1	LATCH ROLLER DU BEARING
11	1	D4994-1	LATCH
12	2	D4995-1	ACTUATOR BUSHING
13	1	D4996-041	HOOK ASSEMBLY
14	1	D4997-1	LOAD BEAM BUMPER
15	2	D4998-1	LOCK BUMPER
16	1	D4999-1	CLOCK SPRING COVER
17	1	D5000-1	CLOCK SPRING
18	1	D5001-1	LOCK SPRING
19	2	D5002-1	LINK PIN
20	1	D5003-1	LINK
21	1	D5005-1	SOLENOID COVER GASKET
22	1	D5006-1	SOLENOID COVER
23	1	D5007-1	MANUAL RELEASE COVER
24	1	D5009-1	ACTUATOR SPRING
25	1	D5010-041	HOOK INTERFACE ASSY
26	1	D5011-041	HOOK SOLENOID ASSY
27	2	D5013-3	BUSHING
28	1	D5020-1	WIRE GUIDE/GRIP
29	1	D5044-1	DOWEL PIN
30	2	D5044-3	DOWEL PIN
31	2	D5045-1	SPLIT DU BEARING
32	1	D5056-1	HOOK PIN
33	2	D5057-1	NYLON WASHER
34	2	D5057-3	NYLON WASHER
35	1	D5065-1	HOOK MANUAL RELEASE LEVER
36	1	D5066-1	PLACARD
37	1	D5066-13	PLACARD

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: LASER ETCH P/N D4983-041, BATCH XX-XXXX-XX, REV. X, DOM XX/XXXX
LOCATE APPROX AS SHOWN USING APPROX LETTERING HEIGHT
AS SHOWN. PER DART EUGENE SPEC QMSI-6.2.2.

- 7) WEIGHT: 5.50 lbs
- 8) WIRING INSTALLATION PER AC43.13-1B CHAPTER 11

ITEM	QTY -041	P/N	DESCRIPTION
38	1	AN3C15A	BOLT
39	1	AN310C6	NUT, CASTELLATED
40	2	AN4C15A	BOLT
41	1	AN4C17A	BOLT
42	2	MS16624-4028	RETAINING RING
43	4	MS16624-5012-1	RETAINING RING
44	1	MS171532	SPRING PIN
45	3	MS21043-3	NUT, SELF-LOCKING
46	3	MS21043-4	NUT, SELF-LOCKING
47	1	MS24665-153	COTTER PIN
48	1	MS24694-C7	SCREW, CSK 100°
49	8	MS24674-9	SOCKET HEAD CAP SCREW
50	1	MS27039C1-08	SCREW, PAN-HEAD
51	4	MS35338-137	LOCK WASHER
52	5	NAS1149C0363R	WASHER
53	6	NAS1149C0463R	WASHER
54	1	NAS1149C0663R	WASHER
55	1	NAS1149C0863R	WASHER
56	1	D5116-5	WIRE M22759/41-14-9
57	1	D5116-7	WIRE M22759/41-14-9
58	1	1-480319	CONNECTOR
59	1	XPF-1/8	EXPANDABLE SLEEVE - 48" LONG
60	2	BT1.5I-M	TIE WRAP

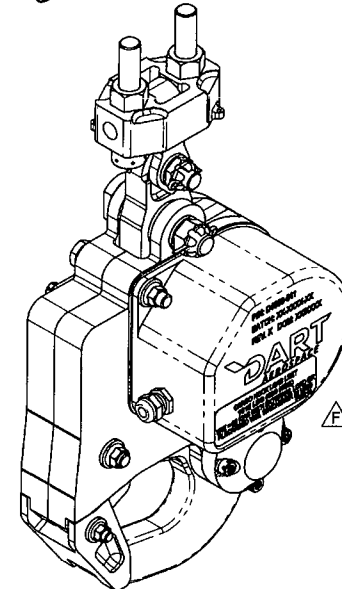


D4983-041 CARGO HOOK ASSY

RELEASE

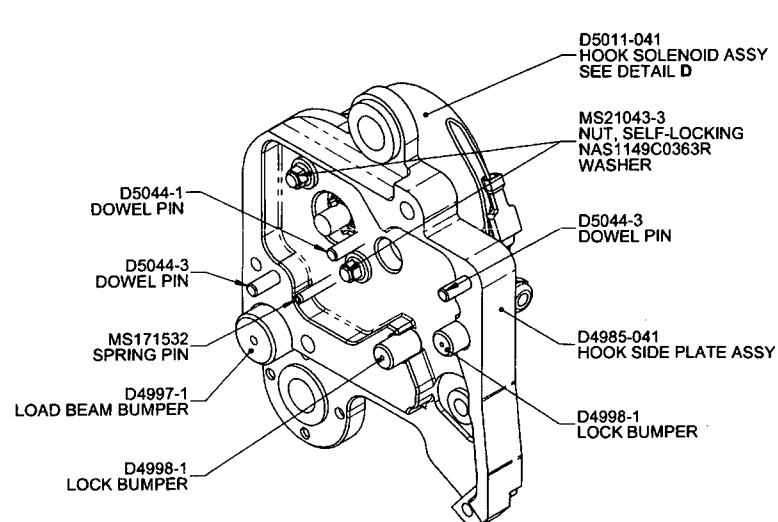
2015 MAR 26
A.P. ECA 15-554

W/O: 130766
02/15/03/30

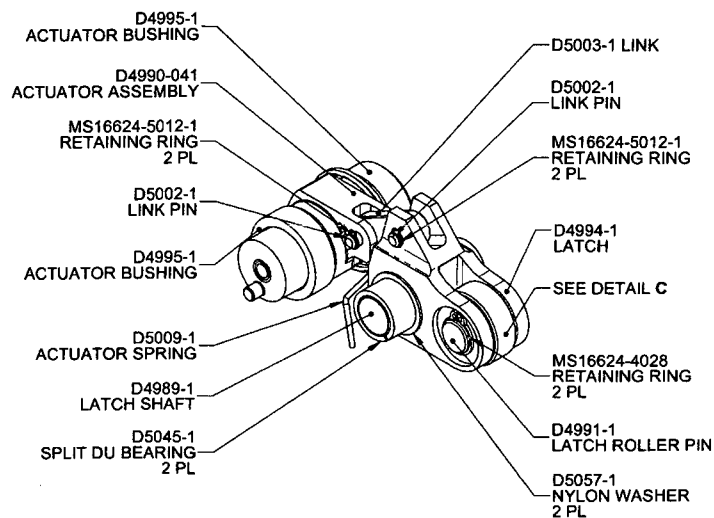


F	D5066-13 WAS D5066-5 (ZN A5-1, C2-1, B8-1 AND C4-3)	AK	15.03.02
E	ADDED ITEMS 56, 57, 58, 59, 60 TO BOM (ZN C5-1). ADDED NOTE 8 (ZN A8-1). UPDATED D5066-5 PLACARD (ZN A5-1, C2-1 AND C4-3). ADDED SHEET 4 (BUILD SEQUENCE 4).	AK	15.02.06
D	ITEM 50 WAS MS27039C0814 (DRAFTING ERROR). ADDED NOTE 6.	AJS	14.12.15
C	PICTORIAL UPDATE FOR CHANGES TO D5010-041 SUB ASSY. PICTORIAL UPDATE TO ITEM 28. ADDED ITEM 37 & 38. QTY FOR ITEM 44 WAS 4 (-9 DELETED). REDESIGNED D4985-041, D5007-1 AND D5065-1 AND UPDATED RELATED HARDWARE LENGTHS. ALL NASM HARDWARE REPLACED WITH ANIMS HARDWARE.	AJS	14.06.24
B	SHT 1 PARTS LIST: ITEM 42 WAS -151. ADDED ITEM 43. QTY FOR ITEM 44 WAS 8. ITEM 47 PART NUMBER WAS NAS1149C0832R. ITEM 51 PART NUMBER WAS NAS1149C0816R. ITEM 52 PART NUMBER WAS NASM24694-C4. REASON: DRAFTING ERROR.	AJS	14.03.13
A	NEW ISSUE	AJS	14.02.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4983 SHEET 1 OF 4 CARGO HOOK ASSY SCALE NTS COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	AK		
CHECKED	RF		
MFG. APPR.	JLM		
APPROVED	HS		
DE APPR.	DS	DATE 15.03.02	

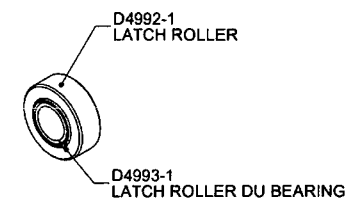
APPROVED



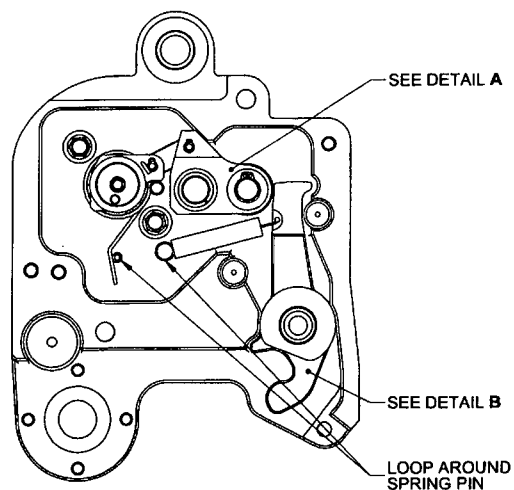
BUILD SEQUENCE 1



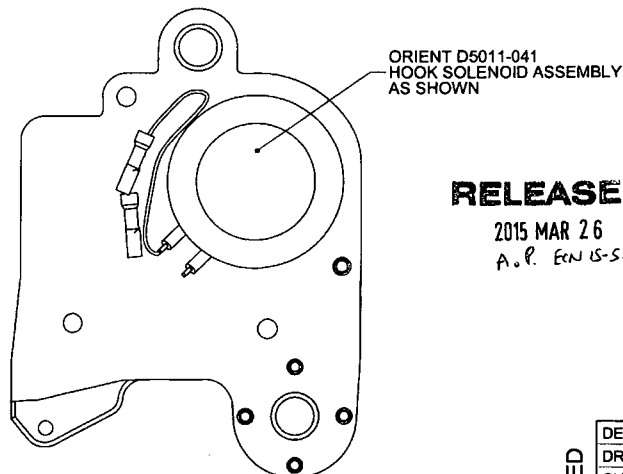
DETAIL A



DETAIL C



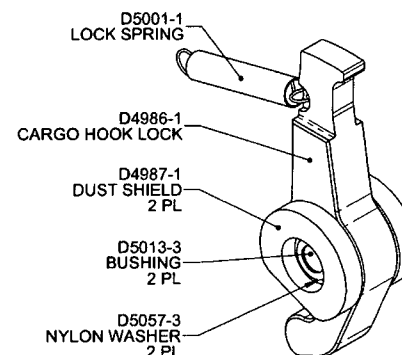
BUILD SEQUENCE 2



DETAIL D

RELEASED

2015 MAR 26
A.P. ECU 15-554

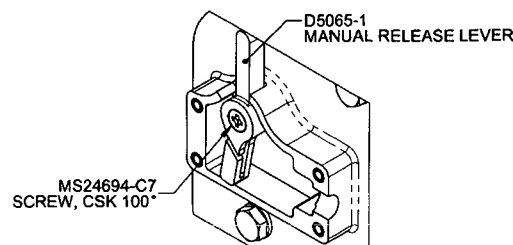


DETAIL B

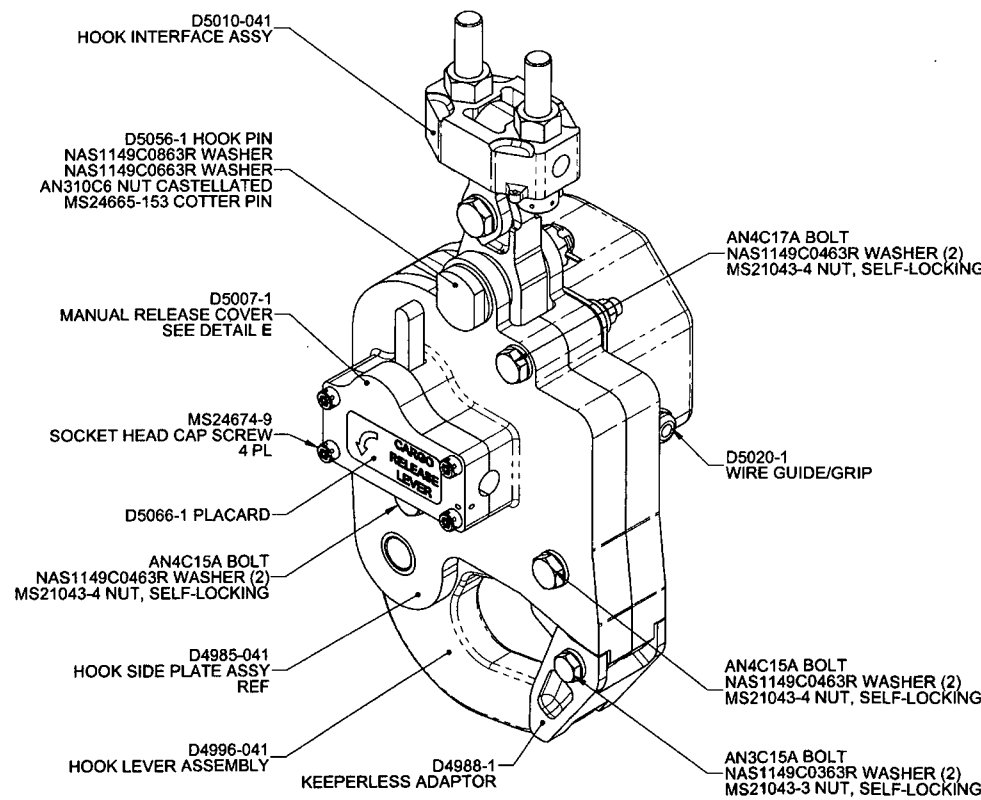
APPROVED

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	JLM	D4983	SHEET 2 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CARGO HOOK ASSY	NT
DATE	15.03.02	COPYRIGHT © 2014 BY DART AEROSPACE LTD	
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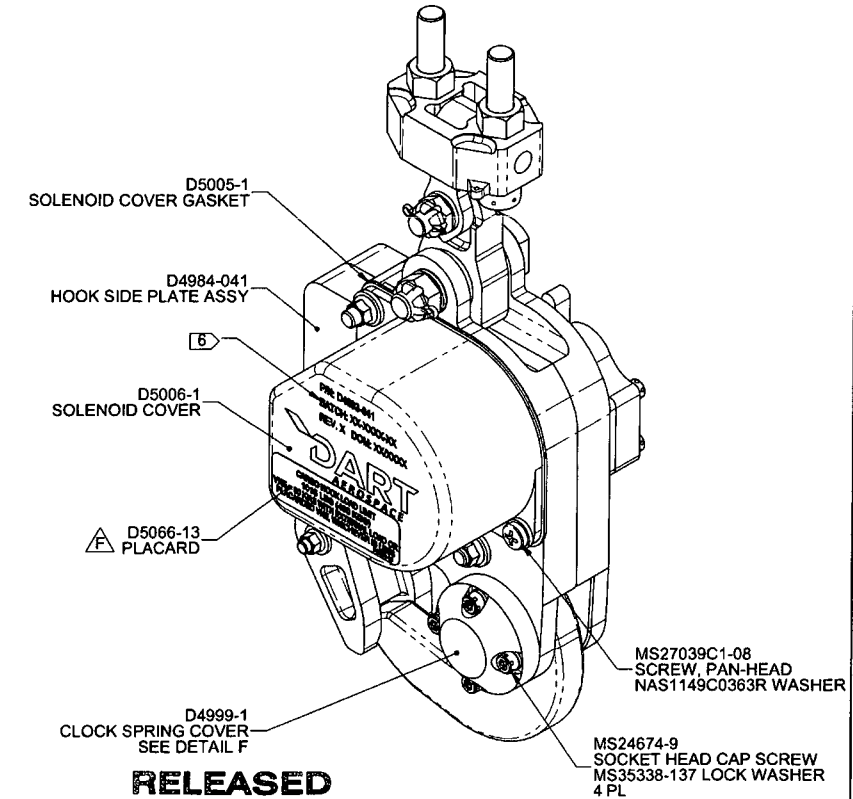
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DETAIL E

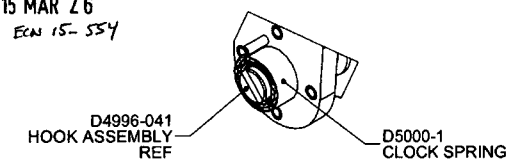


BUILD SEQUENCE 3



RELEASED

2015 MAR 26
A.P. ECU 15-554



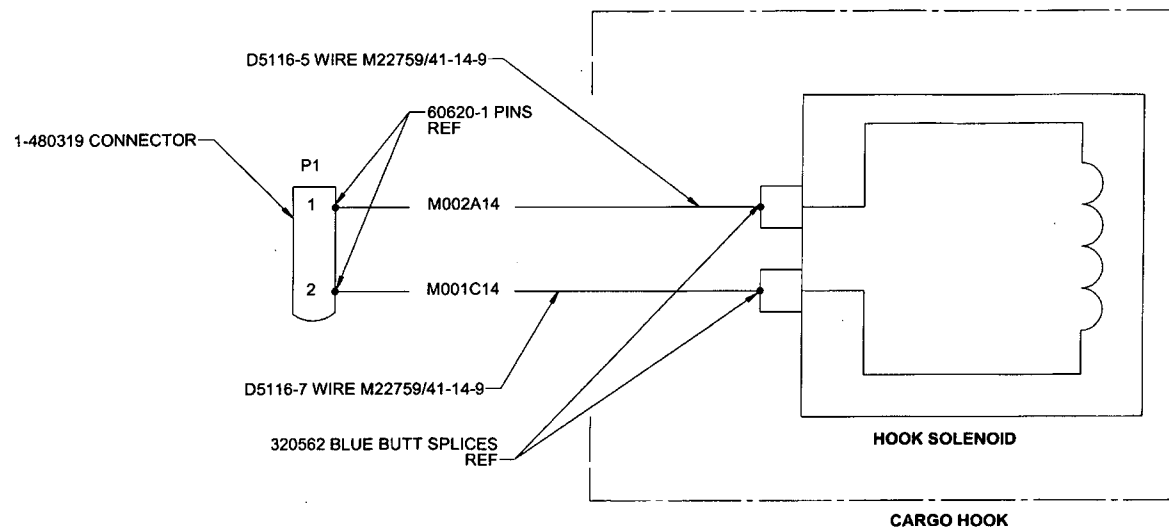
DETAIL F

APPROVED	DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	AK		
	CHECKED	RF	DRAWING NO.	REV. F
	MFG. APPR.	JLM	D4983	SHEET 3 OF 4
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	CARGO HOOK ASSY	NTS
DATE		15.03.02	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

BUILD SEQUENCE 4 INSTRUCTIONS:

1. REMOVE D5006-1 SOLENOID COVER
2. INSTALL PINS ON THE D5116-5/-7 WIRES TO THE 1-480319 CONNECTOR. SEE FIGURE BELOW FOR DETAILS
3. INSTALL XPF-1/8 EXPANDABLE SLEEVE AT THE CONNECTOR END AROUND D5116-5/-7 WIRES AND SECURE USING A SMALL TIE WRAP
4. INSTALL D5116-5/-7 WIRES AND XPF-1/8 EXPANDABLE SLEEVE THROUGH D5020-1 WIRE GUIDE/GRIP ON THE SOLENOID COVER
5. INSTALL TIE WRAP ON EXPANDABLE SLEEVE AND WIRES INSIDE D5006-1 SOLENOID COVER
6. CONNECT D5116-5/-7 WIRES TO SOLENOID WIRES USING 320562 BLUE BUTT SPLICES
7. RE-INSTALL D5006-1 SOLENOID COVER
8. TIGHTEN D5020-1 WIRE GUIDE/GRIP



BUILD SEQUENCE 4

RELEASED

2015 MAR 26

A.P. Ecn 15-554

APPROVED

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AK		
CHECKED	RF	DRAWING NO.	REV. F
MFG. APPR.	JLM	D4983	SHEET 4 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	CARGO HOOK ASSY	NTS
DATE	15.03.02	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27895**

Purchase Order Date 3/25/2015

PO Print Date 3/25/2015

Page Number 1 of 2

Order From :

VU-RED001

RED BARN MACHINE INC.
190 S DANEBO AVE.
EUGENE, OR 97402
USA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 541-344-9953

Ship To Contact

Ship To Phone

Ship Via: FedEx Overnight collect

Ship Acct:

Buyer

Chantal-Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D4983-041P ✓ AS PER DWG D4983 REV. F ^E B130763,B130764,B130765 (B130766,B130767,B130768,B130769,B130771,B130772,B130773)	Cargo Hook Assembly	4/2/2015 Yes 4/2/2015 5/25	FN	10.00 ✓ Each	\$6,048.00	\$60,480.00
						Line Total:	\$60,480.00
2	D5051-041P AS PER DWG D5051 REV. C B130775	Cyclic Switch Housing Assembly	4/2/2015 Yes 4/2/2015 5/25	FN	10.00 Each	\$186.00	\$1,860.00
						Line Total:	\$1,860.00

Note:

3/25/2015



Pack Slip: 18299
18299

Packing Slip

Page: 1 of 1

Ship To:

DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ONTARIO K6A 1K7
CANADA

Phone: 800-556-4166
Fax: 714-755-2995

Sold To:

CHANTAL LAVOIE
DART AEROSPACE LTD.
1270 ABERDEEN STREET
HAWKESBURY ONTARIO K6A 1K7
CANADA

Phone: 800-556-4166
Fax: 613-632-4443
dkennedy@dartaero.com

Ship Date: 5/18/2015

Ship Via: FEDEX INTL P1

F.O.B.: EUGENE, OR

Order: 16263

PO: 27895

Salesperson: ERIC BACON

FEDEX OVERNIGHT COLLECT

PO

Line	Planned Qty	Shipped Qty	Part Number/Description	Rev
	10.00	10.00 <i>KB</i>	D4983-041P	
	10.00	10.00 <i>KB</i>	CARGO HOOK ASSEMBLY	
			D5051-041P	
			CYCLIC SWITCH HOUSING ASSEMBLY	

SP15-05-20

Dart Aerospace hereby certifies that all materials used in the manufacturing of our tools are new and meets all specifications called out in all applicable blueprints and drawings. All standard machining and manufacturing procedures are strictly followed.

[Signature]
Signed

PackSlip:8.03:01

190 S. Danebo Avenue
Eugene, OR, USA 97402
dartaerospace.com

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Mission
Ready.